

5/20
DART AEROSPACE LTD

Work Order:

23022

Description: Wheel Shaft

Part Number:

D3334-1

Dwg: D3334 Rev. A

Qty:

24

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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HJ	05.04.13	24
2	MS	Cut blanks: Ø3.500" Bar to 7.750" long Material: AISI 4140 or ASTM A304-02/A-434-BC/A193-03- Grade-B7/A29-03/A322-91 or UNS# G41400 (M4140H-500) Identify for D3334-1	J.G.	05.10.13	4
3	MS	Turn as per Folio FA492 and Dwg D3334	J.G.	05.10.13	4
4	QC2	Inspect parts as they come off the CNC machine	J.G.	05.10.13	4
5	MS	Deburr	J.G.	05.10.13	4
6	MV	Machine as per Folio FA492 and Dwg D3334 Identify as D3334-1	J.G.	05.10.13	4
7	QC2	Inspect parts as they come off the CNC machine	J.G.	05.10.13	4
8	QC8	Second check	J.G.	05.10.13	4
9	QC5	Inspect work to step 8	J.G.	05.10.13	4
10	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Mask thread and bearing surface	J.G.	05.10.13	4
11	QC3	Inspect Powder Coat			
12	ST	Identify and Stock			
13	AC	Cost / part:			
14	DC	Close W/O Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	
B	05.03.02	Revised material; Added Powder Coat	KJ/JLM	

RELEASED
10/05/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
		change drawing 1-14 UNF thread change to 1-14-UNS 2A	J.G	05/10/19			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/10/19	3	incorrect thread. folio instructions no good.		Program change, notify program engineer. Replace part, do not scrap use for mill set-up	J.G 05/10/19			

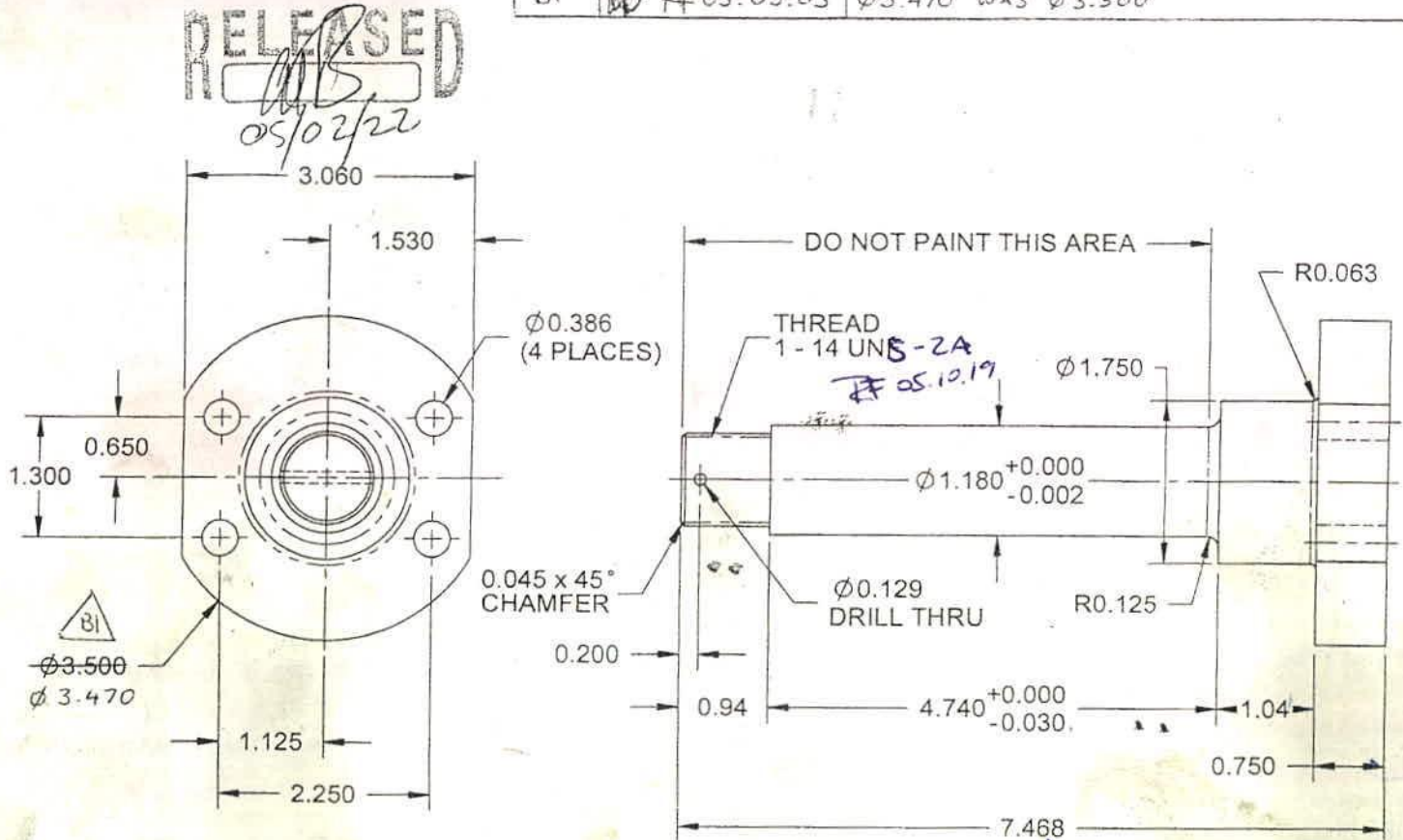
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3334	REV. B SHEET 1 OF 1
DATE 05.02.18		TITLE WHEEL SHAFT	SCALE 1:2
A	04.12.16	NEW ISSUE	
B	05.02.18	REDESIGN TO FIT NEW WHEEL ASS'Y	
BI	05.03.03	Ø3.470 WAS Ø3.500	

**D3334-1 WHEEL SHAFT****NOTES:**

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03-GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 (REF. DART SPEC. M4140H-R3.500)
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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ENGINEERING

UNCONTROLLED COPY

WORK ORDER

NO. 23022

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DART AEROSPACE LTD		Work Order: 23022-C
Description:		Part Number: 03334-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.470	± 0.010	3.477	✓			
1.180	± 0.002	1.180	✓			
1.750	± 0.010	1.749	✓			
0.750	± 0.010	0.752	✓			
1.04	± 0.030	1.040	✓			
4.740	± 0.002	4.735	✓			
0.940	± 0.030	0.945	✓			
7.468	± 0.010	7.471	✓			
R0.063	± 0.010	R0.063	✓			
R0.125	± 0.010	R0.125	✓			
1-14 UNS	N/A	1-14 UNS	✓			
0.200	± 0.010	0.200	✓			
0.129	± 0.005	0.129	✓			
Ø.386	± 0.010	Ø.387	✓			
1.300	± 0.010	1.302	✓			
1.530	± 0.010	1.533	✓			
3.060	± 0.010	3.066	✓			
1.125	± 0.010	1.125	✓			
0.650	± 0.010	0.651	✓			
2.250	± 0.010	2.250	✓			
Ø.386		Ø.387	✓			

} Milling operation

Measured by: S.G / SA	Audited by: J.L	Prototype Approval:
Date: 05/10/20	Date: 05/10/20	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	